

115113

Split

DART AEROSPACE LTD	Work Order:	22791B
Description: Doubler	Part Number:	D3302-1
Dwg: D3302 Rev. A	Qty:	10
		Page 1 of 1

04.11.25
04.12.16
04.03.21

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	HA	05.03.22	20
2	MV	Cut blank: 12.900" x 7.850" 13.150" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-1	SA	05.05.22	20
3	MV	Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-1	EP	05/03/23	20
4	QC2	Inspect parts as they come off the CNC machine	EP	05/03/23	20
5	QC8	Second check	ML	05/03/23	20
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	2	05.03.24	10
7	GB	Form as per Dwg D3302	2	05.03.24	10
8	QC5	Inspect work to Step 7	AD	05/03/23	10
9	FP	Chemical Conversion Coat as per QSI 005 4.1	JG	05/03/29	10
10	QC3	Inspect Chemical Conversion Coat	ML	05.03.29	10
11	ST	Identify and Stock	KA	05/03/31	10
12	AC	Cost / part 40.36	SAC	05.04.01	10
13	DC	Close W/O 40.39 Inspect Level 21	HA	05.04.05	10

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	

RELEASED
04/04/09

DART AEROSPACE LTD	Work Order:	22791
Description: Doubler	Part Number:	D3302-1
Inspection Dwg: D3302	Rev: B7	Page 1 of 1

X

First Article

Prototype

[illegible]

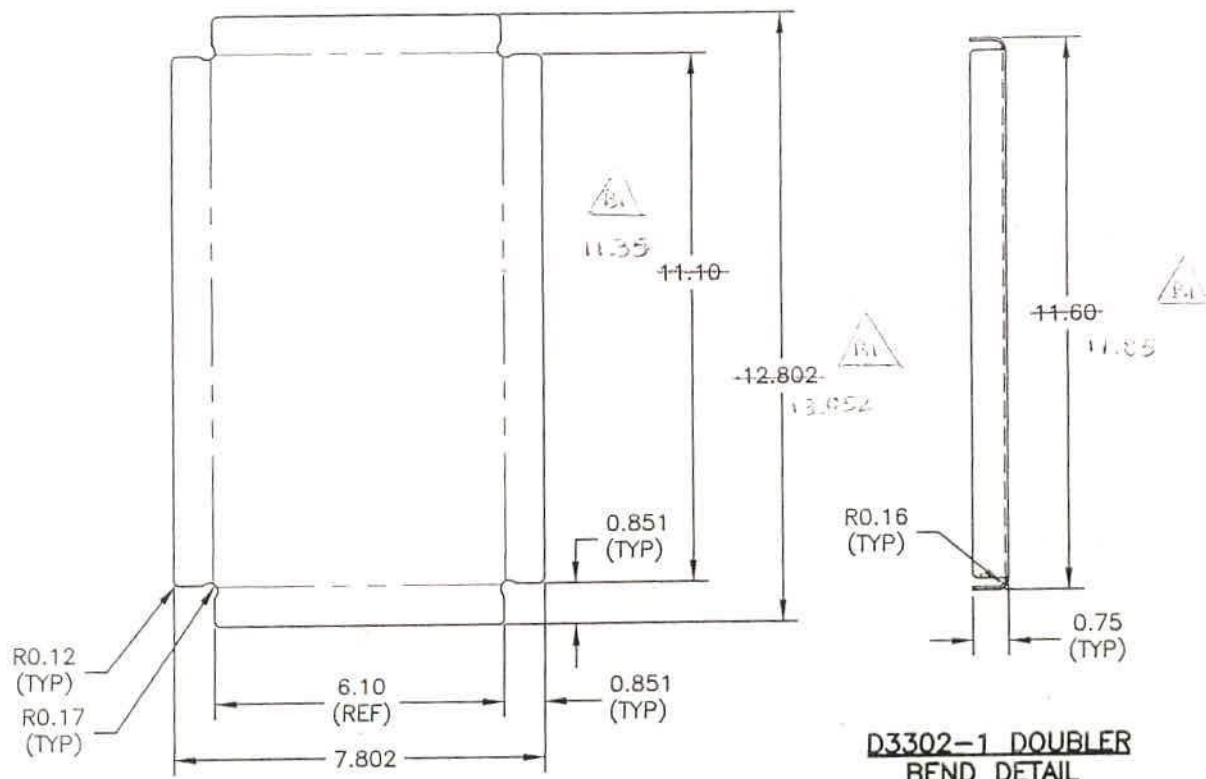
Measured by:	EP	Audited by:	BSL	Prototype Approval:	N/A
Date:	05/03/23	Date:	05/03/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.03.04	Revised dimensions per Dwg revision	KJ/JLM	

DART

DESIGN TH	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TH	APPROVED TH	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18	TITLE DOUBLER		SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	TH 04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3	
B2	TH 05.03.21	7.34 WAS 7.34; 8.947 WAS 9.042; 7.75 WAS 7.84 FOR D3302-3	

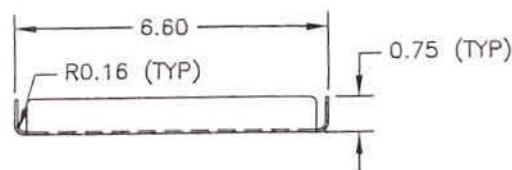
RELEASED
04.11.23



D3302-1 FLAT PATTERN

**D3302-1 DOUBLER
BEND DETAIL**

PRELIMINARY ISSUE



D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.Q63)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

NO. 22791

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 21, 2005
10:23 am

Work Order No : 0022791
Project Name : D3302-1
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D3302-1
Description : Doubler
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 03-21-05
Est Finish Date : 03-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00